Hand Finishing

April-12-13 7:42:34 AM Item ID: D4003-047 Accept *N900040100* Setup Start **Revision ID:** Fuel Pump Inlet Pipe Item Name: **Start Date:** 4/11/13 Start Qty: 4 Cust Item ID: Required Date: 4/11/13 Req'd Qty/4.00 **Customer:** Reference: Date: 1304 Tooling: Run **Approvals:** Date: Stop Date: SPC (Y/N): Date: Sequence ID/ Operation Set Up/ Tool ID Tool # Plan Reject Accept Reject Insp. **Work Center ID** Description **Run Hours** Qty Code Qty Number Stamp **Draw Nbr Revision Nbr** D4003 Α 100 -0.00 *100* Small Fab 0.00 Memo Small Fab 1- Cut tube 12.00" long 2- Bend as per dwg 110 QC5- Inspect part completeness to step on W/O *110* QC Memo Quality Control 150 Chemical Conversion Coat per QSI005 4.1 0.00 8 18.430 *150* HandFinish 0.00 Memo

| | i | 1 | | | | | | | | DQA: | Date: | |
|-----------------------|--------------------|-----------|----------|-----|-------------------------------|----------|---------|------------------------------------|-------------|----------------------------|--|-----------------------|
| NCR: Y | es / No | 1 | | | WORK ORDER NON- | CON | IFORM | MANCE / UP | PDATE | | | |
| | | Ų | | | | | | | | QA Closed: | Date: | |
| Work Orde | .r. | i į | | | DISPOSITION | | | | AGAINST DI | EPARTMENT | PROCESS | |
| WOIK OIGE | 7 | 1 | | | Rework | 7 I | | Skid-tube | Crosstube | 7 | Water Jet | Engineering |
| Part N | 0. | ij | | | Scrap | 7 | | Machining | Small Fab | Pro | d. Eng. Coor. | Quality |
| | | 1 | 11 | | Use-as-is | | Thern | noforming | Finishing | Rec/Stor | e/Packaging | Other |
| NCŖ N | 0. | | | | Work Order Update |] | | Large Fab | Composite | | Supplier | |
| | | (| | | | | | | | T 6: 0 | | |
| Root | | 6.1 | | | cription of work order update | | nitial | i | ction | Sign & Date | Verification | QC Inspector |
| Cause | Date | Step | Qty | | or Non-conformance | Cn | ief Eng | Desc | cription | Date | verification | QC ITSPECTOR |
| Doc/Data | | 1 # | | 1 ; | | | | | | 1 | | , |
| Equip/Tooling Derator | | 1 1 | | 1 | | | | | | | | |
| Material | - . | | | | | | | | | | | |
| Setup | | | | İ | | | | | | | | |
| Other | | ! | | | | | | | | | | |
| Process | - † | | | | | | | | | | | |
| Supplier | | | | | | | | | | | | |
| Training [| 1 | ; | | | | | | | | | | |
| Jnapproved | | Lij | | | | _i | | | | | | |
| | | | | | | FAUL | T CATE | GORY | | | | |
| Landir | ng Gear | 1 | | | General | | | | _ | 7 | | 7 |
| | Bending | () :1 | | | Bend | | Grain | | - | Ovalized | A-1 | Pressure/Forced |
| } | Centre No | ot Concer | itricito | O/S | BOM/Route | | Hardwa | | | Over/Under Part Incorre | , | Temperature/Cure Weld |
| } | Cracks | السلال | | | Broken/Damaged | \vdash | • | ion Incomplete ions Incomplete, | /Unclose | Part Incorre | | Wrong Stock Pulled |
| } | Crushed/ Cuffs | Crimped | | İ | Burrs Contamination | | Mainte | · | / Officieal | Part Moved | 33111g | J WY ONE STOCK I WHEN |
| ł | Heat Trea | , | | | Countersink | | Mislabe | | <u> </u> | Positioned V | Vrong | |
| } | Inspection | - 11 | Tube | | Cut Too Short | | Misread | | - | Power Loss/ | _ | Other |
| ŀ | Ripples in | 11 1 | | | Drill Holes | | Offset | - | <u>L</u> | | <u> </u> | |
| ļ ļ | Torque W | | xtrusi | on | Drawing | | | Calibration | | | | · · |
| ţ | Turning S | F1 1 | | | Finish | - ⊢ | | Sequence | | | | |
| | Wave/Tw | | e | | Folio | | Outside | Dimensions | | | | |

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Work Order ID 99805

April-12-13 7:42:34 AM

99805

| Item ID: Revision ID: | D4003-047 | | | Accept | * | 1900 | 040 | 1100 |)* s | Setup Star | * *N | S1* |
|--|----------------------|------------------------------------|------------------------|--------------------|--------|--------------------------|--------|--------------|---------------|---------------|------------------|----------------|
| Item Name: | Fuel Pump In | let Pipe | , | | | | | | | Stop | · *N | S2* |
| Start Date: Required Date Reference: | 4/11/13 : 4/11/13 | Start Qty: 4.00 Req'd Qty: 4.00 | *4* *4* | | | Cust Item Customer: | ID: | | | | ′ | |
| Approvals: | Process Pla | ın: | Date: | Tooling: | | D: | ate: | - | F | Run Star | * *N | R1* |
| | QC: | | Date: | CDC (VAN | | | ate: | | | Stop | | R2* |
| Sequence ID/ Work Center I | D | Operation Description | | Set Up/ Run Hou | urs | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
| *161* Small Fab | · | Memo | | 0.00 | | | | | 8 | | <u> 13</u> - | F -04-30 |
| Small Fab | | 1- intall slee | ve and nut | | | | | | | | | |
| | | 2-flare ends | as per dwg | | | | | | | | | |
| *162 *16 2 * | | QC5- Inspect part comple | eteness to step on W/O | 0.00 | day. | | | | 8 | | | |
| QC Quality Control | | Мето | | 0.00 | 3.5.0) | | | | | | | |
| 170 | | Identify as per dwg & Sto | ock Location: | 0.00 | 1 | · | | | | | 2/1 | |
| *170* Packaging Packaging | | Мето | 50243 | 0.00 | | | | | (| | 5/6/8 | |

| | | | | | | | | 443465 / 115 | D.A.T.C | DQA: | Date | |
|---|---|--|------|---|--|------|---|---|---|--|---|---|
| NCR: Y | es / No | | | | WORK ORDER NON-C | .ON | IFORM | MANCE / UP | DATE | QA Closed: | Date | |
| Work Orde | r· | | . | | DISPOSITION | | | | AGAINST DE | PARTMENT | PROCESS | |
| Part N NCR N | 0. | | | | Rework Scrap Use-as-is Work Order Update | | Thern | Skid-tube Machining noforming Large Fab | Crosstube Small Fab Finishing Composite | 4 | Water Jet d. Eng. Coor. re/Packaging Supplier | Engineering Quality Other |
| Root Cause | Date | Step | Qty | | ption of work order update or Non-conformance | ł | nitial ief Eng | | tion ription | Sign & Date | Verification | QC Inspector |
| oc/Data quip/Tooling Operator Material Setup Other Process Supplier Fraining Unapproved | | | | | | | | | | | | |
| | | | | · | | AUL' | T CATE | GORY | | | | |
| Landir | Cracks Crushed Cuffs Heat Tro Inspecti Ripples Torque Turning | Not Concer //Crimped eat on Strip in in Bend Wayes in E Sequence | Tube | | General Bend BOM/Route Broken/Damaged Burrs Contamination Countersink Cut Too Short Drill Holes Drawing Finish | | Instruct Mainte Mislabe Misread Offset Out of S | on Incomplete ions Incomplete/ enance eled d Calibration Sequence | Unclear | Ovalized Over/Under Part Incorred Part Lost/Mi Part Moved Positioned V Power Loss/ | ct ssing Vrong | Pressure/Forced Temperature/Cure Weld Wrong Stock Pulled Other |
| <u>_</u> | Wave/1 | wist in Tub | e | | Folio | | Outside | Dimensions | | | | |

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

April-12-13 7:42:34 AM

Item ID: D4003-047 Accept *N900040100* Setup Start **Revision ID:** Item Name: Fuel Pump Inlet Pipe **Start Date:** 4/11/13 Start Qty: 4.00 **Cust Item ID:** Required Date: 4/11/13 Req'd Qty: 4.00 **Customer:** Reference: Run Start Process Plan: ____ Date: ___ Approvals: Tooling: Date: Stop QC: Date: SPC (Y/N): Date: Sequence ID/ Operation Set Up/ Tool ID Tool # Plan Reject Accept Reject Work Center ID Description **Run Hours** Qty Qty Code Number Stamp 180 QC21- Final Inspection - Work Order Release 0.00 *180* OC 0.00 Memo Quality Control

G 13450

| • | i | | . | | | | | | | | | DQA: | Date: | | |
|--|----------------|------------------|----------|----------|--------|----------|--|------------|--------------------|------------------------------|-----------------------------------|-----------------------------|--|---------------------------------|-------------|
| NCR: Y | es / | No | | 1 | | | WORK ORDER NON-C | ON | NFORM | MANCE / UPDATE | | QA Closed: | Date: | | 4 |
| · · · · · · · · · · · · · · · · · · · | | | | | | | DISPOSITION | | | Δ. | | PARTMENT/ | | | |
| Nork Orde | r: 丄 | | | | | | DISPOSITION | Ì | | purions, | | 7.1111VIEIVI | · · | | |
| Part N | 1 | | : | . | | | Rework Scrap Use-as-is Work Order Update | | t Therm | Machining Sn noforming Fi | osstube mall Fab inishing mposite | | Water Jet I. Eng. Coor. e/Packaging Supplier | Engineering Quality Other | |
| Root | | | | | Des | cri | otion of work order update | | nitial | Action | | Sign & | | 1, | - |
| Cause | . [| Date | Step | фtу | | Ç | r Non-conformance | Ch | ief Eng | Description | n . | Date | Verification | QC inspect | or |
| oc/Data quip/Tooling perator laterial etup ther rocess upplier raining | | | | | | | | | | | | | | | |
| | 1 | | | | | | F.A. | \UL | T CATE | GORY | · | | | | |
| Landir | | | | | | | General | | ۰ . | | | | |] | |
| | | nding | | | | <u> </u> | Bend | Н | Grain | | ├ | Ovalized | talaranss | Pressure/Forced | |
| | | ntre Not icks | Concer | itricito | O/S | - | BOM/Route Broken/Damaged | \vdash | Hardwa Inspecti | ire ion Incomplete | · | Over/Under Part Incorred | | Temperature/Co | are : |
| Ì | | ished/Cr | imped. | | | | Burrs | П | 1 ' | ions Incomplete/Unclea | ar 🗌 | Part Lost/Mi | ssing | Wrong Stock Pu | lled |
| | Cu | | | | 1 | | Contamination | | Mainte | · | | Part Moved | · Laur | • | |
| Ī | He | at Treat | 1 . | | 1 | | Countersink | | Mislabe | eled | | Positioned V | Vrong | - | |
| | Ins | pection S | Strip in | Tube | i I | | Cut Too Short | | Misread | d . | | Power Loss/ | Surge | Other | |
| Ī | Rip | ples in B | end | | i | | Drill Holes | | Offset | | | | | ··· | |
| İ | То | rque Wav | ves in E | xtrusi | on | | Drawing | | Out of (| Calibration | | | | | |
| | Tu | rning Sec | uence | | | | Finish | | Out of S | Sequence | | | | | |
| 1 | T _w | ave/Twist | t in Tuk | pe | [| | Folio | | Outside | Dimensions | | | | | |

Ficklist Print

April-12-13 7:42:37 AM

Work Order ID: 99805

D4003-047

Parent Item Name: Fuel Pump Inlet Pipe

99805

D4003-047

Start Date: 4/11/13

Required Date: 4/11/13

Start Qty: 4.00

Required Qty: 4.00

Comments:

Parent Item:

IPP rev A 10.01.12 new issue prelim EC verified by:DD IPP Rev B

| Component Item ID/ tem Name | Replacement Item ID | Mfg/ Purch | Bin Item | Primary Location | Last Location | Route Seq ID | Unit of Measure | Qty on Hand | Qty per Kit | Total Qty | Qty Issued | Date Issued | Status |
|-----------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|--------------|---------------|----------------|--------|
| 6061T6T0.375W.035 | | Purchased | No | | | 100 | f | 233.4472 | 0.98 | 3.92 | | | ····· |
| M6061T6 ol-T6 RD Tube .375 x.0 | | W 035* | | | | | | | ** | - | FF | 13 | -04- |
| | | | | <u>Location</u> | | Loc (| <u>Oty</u> | Loc Code | | | | | |
| | (| | | MAT014 | - | 233.4 | 1472 | | · | | _ | | • |
| | | | | | 112652 | 125.4 | | | _ | 7.84 | <u>/</u> . | | |
| 818-6D a | | December 1 | Nia | | 124491 | | 108 | | _ | | - | | |
| | D + | Purchased | No | | | 161 | Each | 31.0000 | 2 | 8 | | | |
| 4N818-6 | I)* | | | | | | _ | | ** | | | FF | 13-00 |
| | | • | | Location | | Loc (| <u>Oty</u> | Loc Code | | | | | |
| | | | | ST348 | | | 31 | | _ | | _ | | |
| | | | | | 119438 | | 1 | | _ | A | . / | | |
| :0819-6D | • | | | | 124561 | | 30 | | | 81 | 0 | | |
| | | Purchased | No | | | 161 | Each | 31.0000 | 2 | 8 | | | |
| <u>/</u> IS20819 | 9-6D* | | | | | | | | ** | | | FF | 13.0 |
| | | | | Location | 4 | Loc (| <u>Oty</u> | Loc Code | | | | | |
| | | | | ST312 | | | 31 | | | | | | • |
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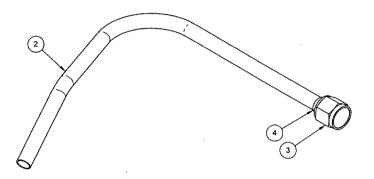
| | ! | : | | | · | | | | | DQA: | Date | |
|---|--|---|---------------------|-----|--|--|--|---|---|--|---|--|
| NCR: Y | es / | No ! | | | WORK ORDER NON-G | CONFO | ORN | MANCE / UPC | DATE | QA Closed: | Date | |
| Work Orde | | :} | | | DISPOSITION | | | | AGAINST DE | PARTMENT | PROCESS | |
| Part N | lo. | | | | Rework Scrap Use-as-is Work Order Update |] T1 | nerm | Skid-tube Machining noforming Large Fab | Crosstube Small Fab Finishing Composite | l | Water Jet d. Eng. Coor. re/Packaging Supplier | Engineering Quality Other |
| Root Cause | Da | te Step | Qty | 1 | iption of work order update or Non-conformance | Initia Chief | ı | Acti Descr | | Sign & Date | Verification | QC Inspector |
| Doc/Data Equip/Tooling Operator Material Setup Other Process Supplier Training Unapproved | | | | | | | | | | | | |
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| Landii | Crac Crus Cuffs Heat Inspering Ripp Torq | re Not Concors Treat ection Strip i es in Bend ue Waves in ing Sequenc | n Tube Extrusion | | General Bend BOM/Route Broken/Damaged Burrs Contamination Countersink Cut Too Short Drill Holes Drawing Finish | Insi Insi Ma Mis Off Ou | rdwa pecti truct ainte slabe sread set t of C | on Incomplete ions Incomplete/U nance led L Calibration equence | Jnclear | Ovalized Over/Under Part Incorre Part Lost/M Part Moved Positioned V Power Loss/ | ct issing Vrong | Pressure/Forced Temperature/Cüre Weld Wrong Stock Pulled Other |
| | . Wav | e/Twist¦in Tu | ube | i I | Folio | Ou | tside | Dimensions | | | | |

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

3 2 JOHN CAMERON AVIATION PART NUMBER ITEM NO. PART NUMBER DESCRIPTION X 1 D4003-047 **FUEL PUMP INLET PIPE** JCA-M47-2-16 2 D4003-7 FUEL INLET PIPE 99805 pl 13-04-14 3 2 AN818-6D NUT 4 2 MS20819-6D SLEEVE **D4003-047 FUEL PUMP INLET PIPE** NEW ISSUE 10.02.05 REV. DESCRIPTION BY DATE DESIGN DART AEROSPACE LTD NOTES: 1) MATERIAL: N/A DRAWN HAWKESBURY, ONTARIO, CANADA DRAWING NO. 1) MATERIAL: NIA
2) FINISH: NIA
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4003-047" AND B/N USING FINE POINT PERMANENT INK MARKER
7) WEIGHT: 0.07 lbs CHECKED REV. A D4003 MFG. APPR. SHEET 1 OF 9 APPROVED TITLE SCALE LINE DE APPR. NTS DATE 10.02.05 3

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| ITEM NO. | QTY. -049 | PART NUMBER | DESCRIPTION | JOHN CAMERON AVIATION PART NUMBER |
| 1 | х | D4003-049 | TANK VENT LINE ASSEMBLY | JCA-M47-2-17 |
| 2 | 1 | D4003-9 | VENT LINE | |
| 3 | 1 | AN818-8D | NUT | |
| 4 | 1 | MS20819-8D | SLEEVE | |



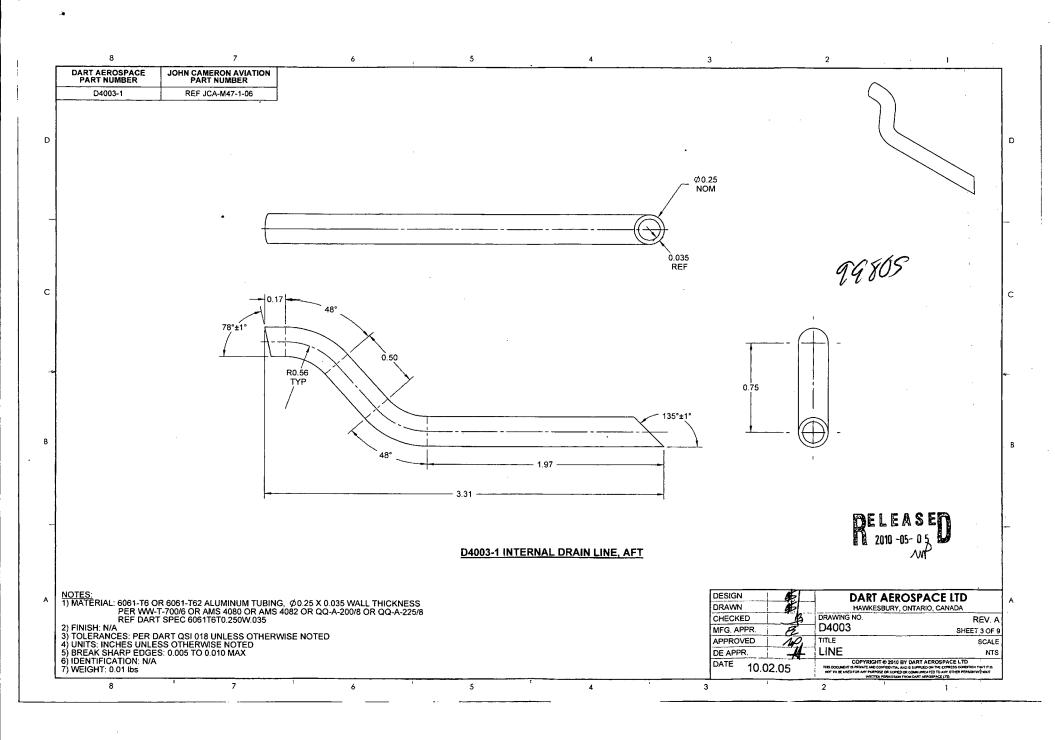
D4003-049 TANK VENT LINE ASSEMBLY

DELEASET N 2010 -05- 0 5

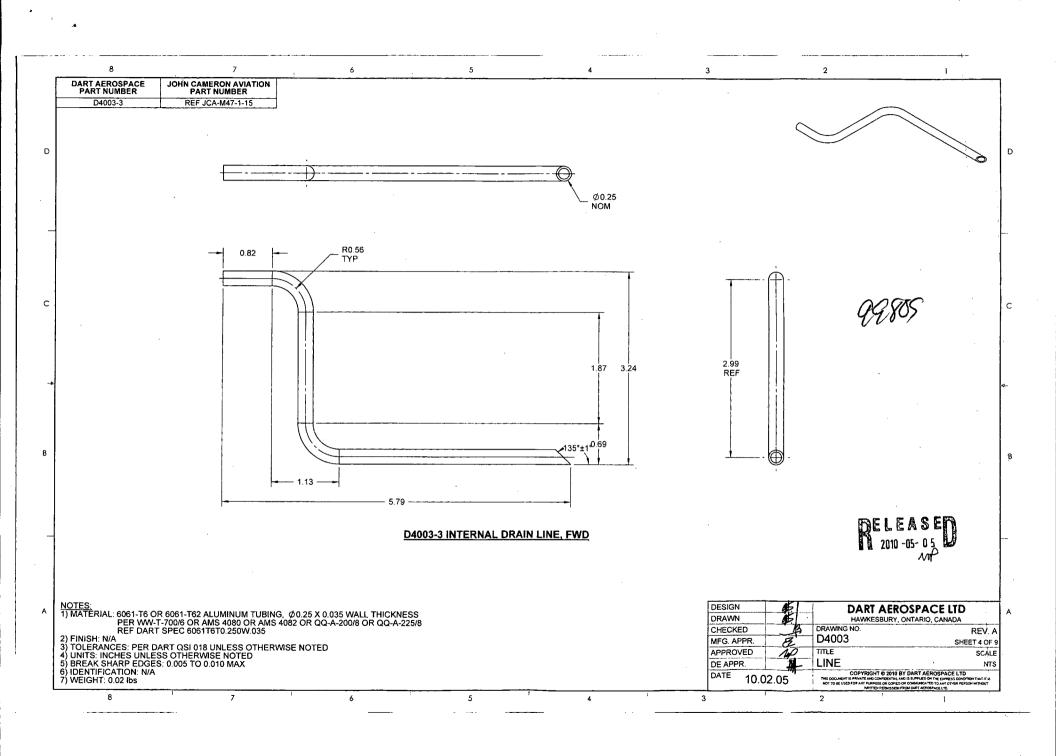
NOTES:
1) MATERIAL: N/A
2) FINISH: N/A
2) FINISH: N/A
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4003-049" AND B/N USING FINE POINT PERMANENT INK MARKER
7) WEIGHT: 0.11 lbs
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6
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| DESIGN | 1 | DART AEROSP | ACE LTD |
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| DRAWN | 3 5 | HAWKESBURY, ONTA | |
| CHECKED | B | DRAWING NO. | REV. A |
| MFG. APPR. | E | D4003 | SHEET 2 OF 9 |
| APPROVED | 14 | TITLE | SCALE |
| DE APPR. | # | LINE | NTS |
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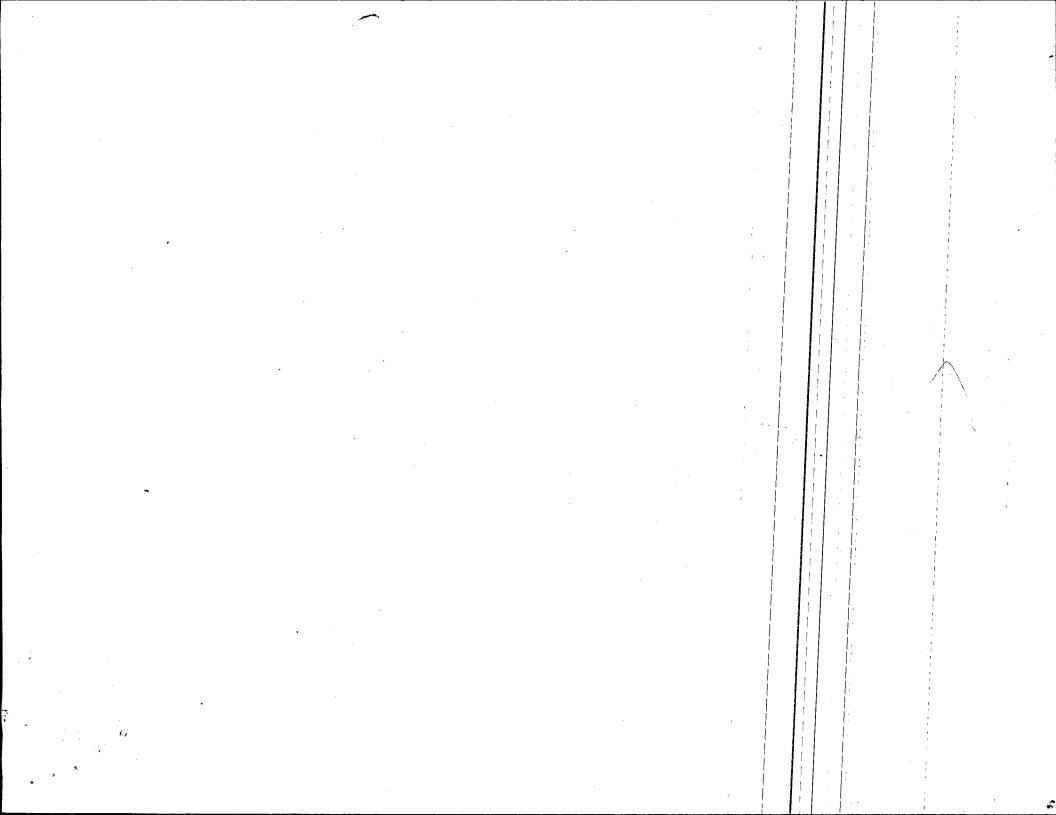
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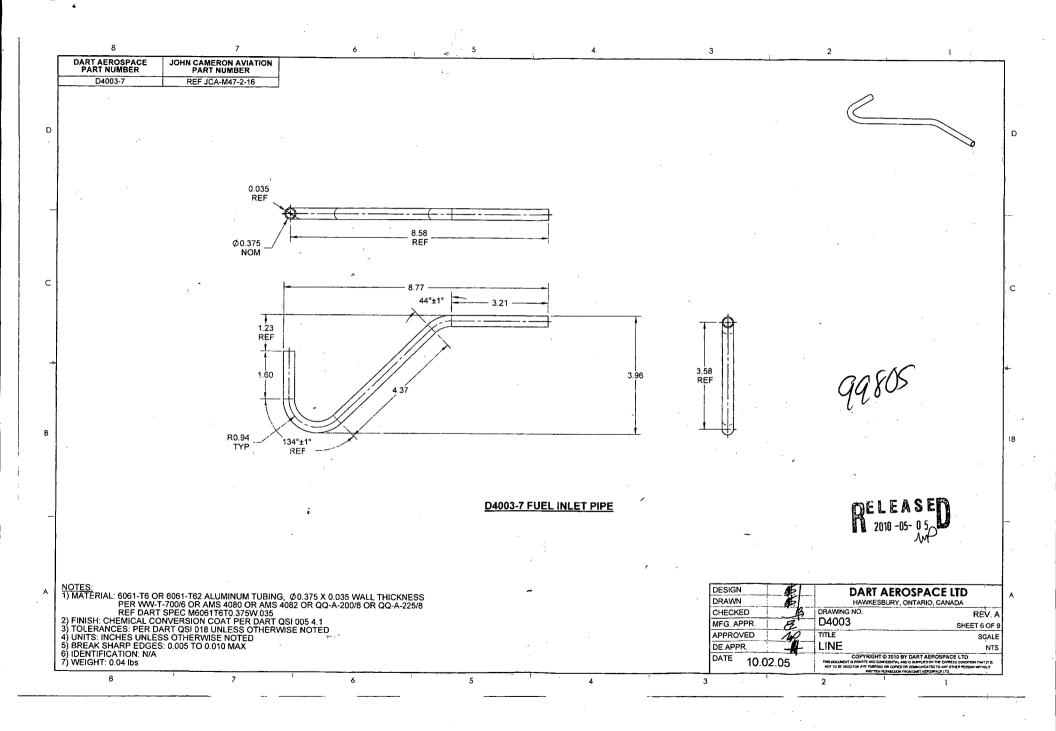
5 3 2 DART AEROSPACE PART NUMBER JOHN CAMERON AVIATION PART NUMBER D4003-5 REF JCA-M47-1-10 2.88 REF 2.78 REF 0.19 TYP Ø0.098 THRU Ø0.50 56 PL NOM 0000000000000 0000000000 99999999999 - 0.34 -0.035 REF **D4003-5 FUEL PICK UP LINE** NOTES: 1) MATERIAL: 6061-T6 OR 6061-T62 ALUMINUM TUBING, Φ0.500 X 0.035 WALL THICKNESS REF WW-T-700/6 OR AMS 4080 OR AMS 4082 OR QQ-A-200/8 OR QQ-A-225/8 REF DAT SPEC M6061T6T0.500W.035 DESIGN DART AEROSPACE LTD DRAWN HAWKESBURY, ONTARIO, CANADA DRAWING NO. CHECKED REV. A D4003 MFG. APPR. SHEET 5 OF 9 2) FINISH: N.Y.
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: N/A
7) WEIGHT: 0.17 lbs TITLE APPROVED SCALE LINE DE APPR. NTS COPYRIGHT © 2010 BY DART AEROSPACE LTD
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NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PEPER DATE 10.02.05

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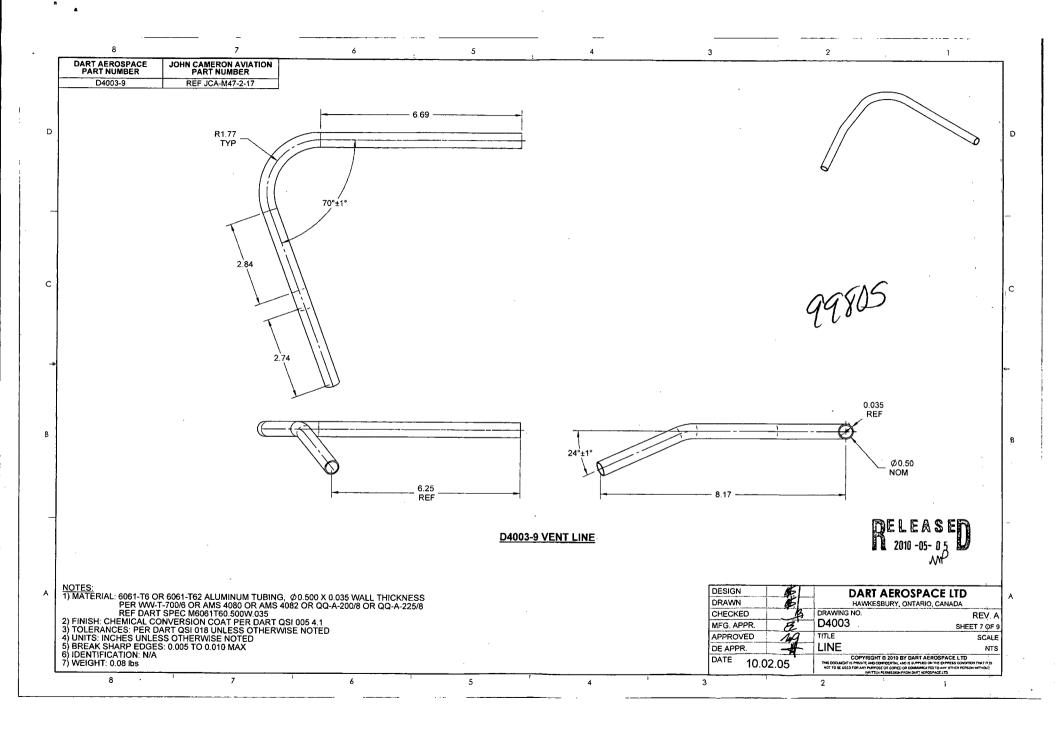
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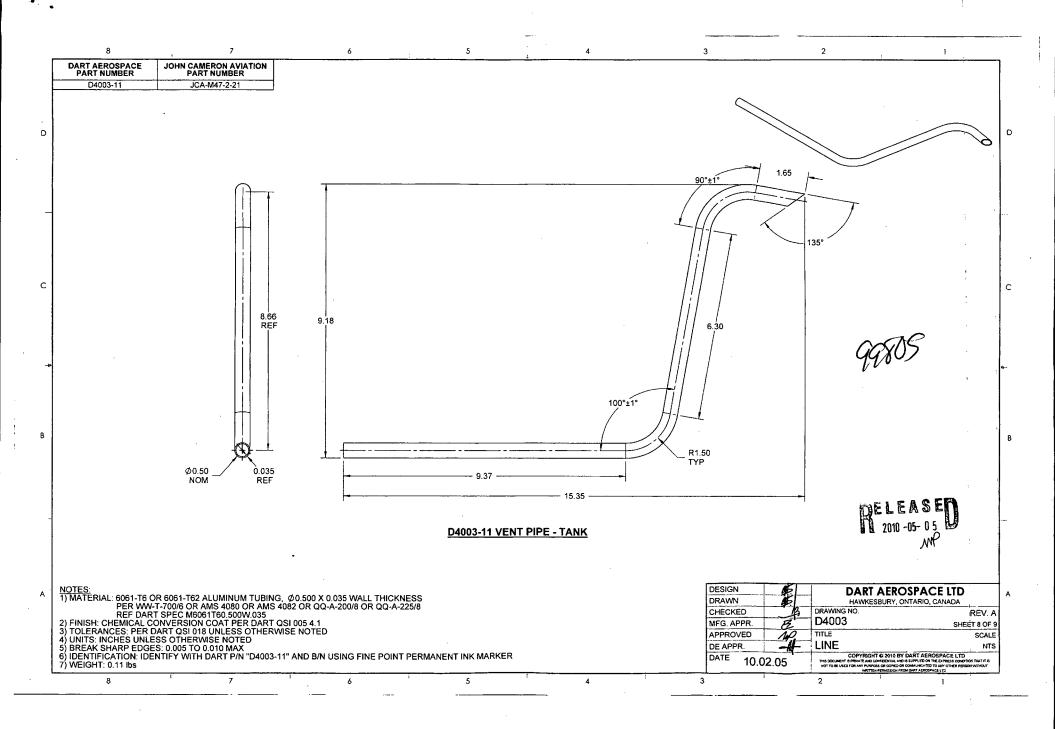




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